

Work Order ID 74356

Wednesday, September 28, 2011 3:26:32 PM

Page 1

Item ID: D2662-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, LH In 206

Start Date: 9/28/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/09/28 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: 5

FOLIO REV: AA

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74356

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Page 2

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Start Date: 9/28/2011 Start Qty: 20.00



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Required Date: 10/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		B.A 11/11/25 FK 11/11/26.		10			
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		amf 11/11/28		10	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10		BL 11-11-29.	

W/O:		WORK ORDER CHANGES					
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Page 4



Item ID: D2662-1

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Setup Start



Revision ID:

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Item Name: Saddle, LH In 206

Start Date: 9/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/11/30

MF
11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 3:26:39 PM

Page 1

Work Order ID: 74356



Parent Item: D2662-1



Parent Item Name: Saddle, LH In 206

Start Date: 9/28/2011

Required Date: 10/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C 00.06.22 Removed P/O for powder coat EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

25.0000

1

20



Da 11/11/24

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

25

66965

1

69677

2

73768

22

→ 73774

16.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74356
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.140	0.138	.139	.139		
B	0.100	0.140		0.125	0.125	.126	.126		
C	1.125	1.145		1.1435	1.1365	1.1350	1.1352		
D	0.615	0.685		0.685	0.685	.685	.685		
E	0.240	0.260		0.245	0.249	.249	.249		
F	1.313	1.343		1.322	1.323	1.322	1.322		
G	0.210	0.230		0.222	0.219	.219	.219		
H	0.100	0.180		0.135	0.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5835	1.5765	1.5748	1.5747		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.111	.111	.111	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.000	6.000	6.000	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	.314	.314		
S	0.315	0.322		0.316	0.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.367	1.362	1.362		
V	0.787	0.807		0.797	0.797	.795	.795		
W	0.540	0.560		0.550	0.550	.547	.547		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	.260	.260		
Z	0.912	0.932		0.923	0.923	.923	.921		
AA	0.490	0.510		0.500	0.500	.499	.499		
AB	0.178	0.198		0.188	0.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: B.A. / EK
Date: 11/11/25 / 11/11/26

Audited by: CMZ
Date: 11/11/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74356
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		.140	.140	.140	.139		
B	0.100	0.140		.124	.124	.125	.124		
C	1.125	1.145		1.1338	1.1342	1.1348	1.1339		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.249	.249	.249	.249		
F	1.313	1.343		1.321	1.320	1.321	1.320		
G	0.210	0.230		.219	.218	.217	.217		
H	0.100	0.180		.135	.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5755	1.5752	1.5750	1.5759		
K	0.235	0.240		.237	.237	.237	.238		
L	0.100	0.120		.111	.111	.111	.112		
M	0.990	1.010		1.000	.999	.999	.999		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.000	5.998	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.795	.796	.797		
W	0.540	0.560		.547	.547	.549	.547		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.260	.260	.260	.260		
Z	0.912	0.932		.922	.922	.922	.923		
AA	0.490	0.510		.499	.499	.497	.501		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: RF
Date: 11/11/26

Audited by: [Signature]
Date: 11/11/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI.9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 74356
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9X	10 2	3	4	By	Date
A	0.100	0.140		.140	.139				
B	0.100	0.140		.125	.125				
C	1.125	1.145		1.1351	1.1342				
D	0.615	0.685		.685	.685				
E	0.240	0.260		.249	.249				
F	1.313	1.343		1.322	1.321				
G	0.210	0.230		.218	.216				
H	0.100	0.180		.135	.135				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.5736	1.5755				
K	0.235	0.240		.237	.237				
L	0.100	0.120		.111	.111				
M	0.990	1.010		1.000	.999				
N	0.510	0.515		.512	.512				
O	5.990	6.010		6.000	5.999				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.314	.314				
S	0.315	0.322		.316	.316				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.795	.795				
W	0.540	0.560		.549	.547				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.260	.260				
Z	0.912	0.932		.923	.921				
AA	0.490	0.510		.497	.499				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>FK</i>
Date: 11/11/20

Audited by: <i>[Signature]</i>
Date: 11/11/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

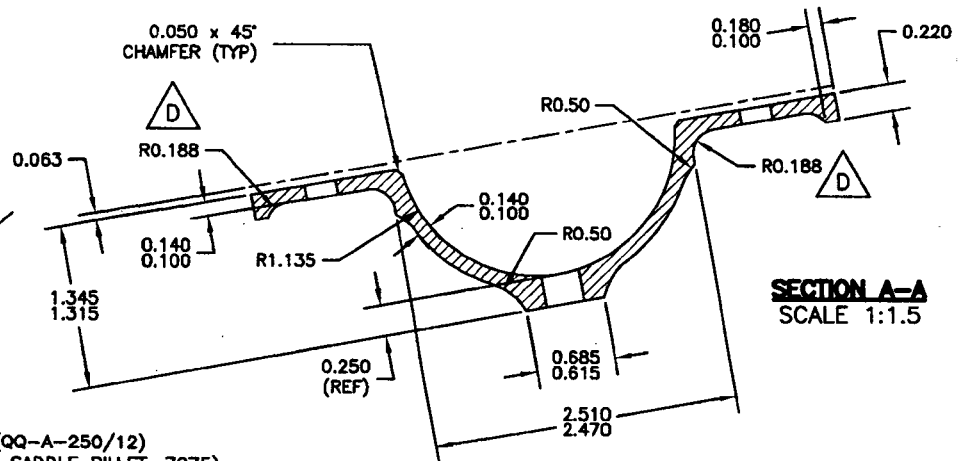
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07.02.12 #

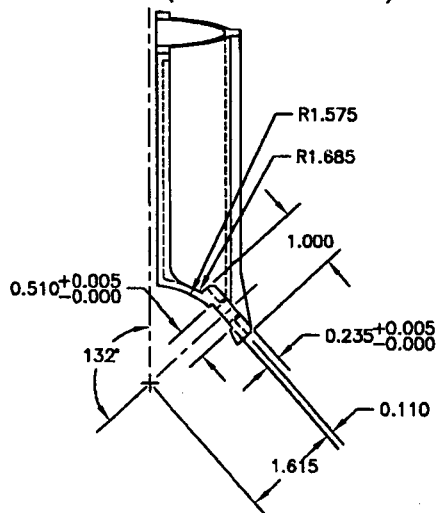
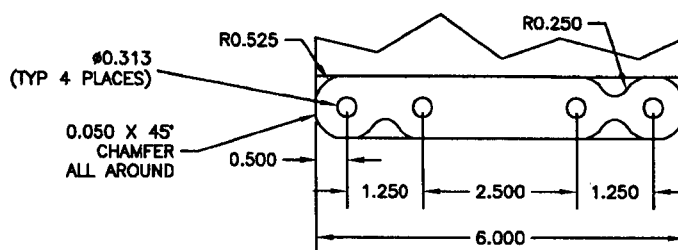
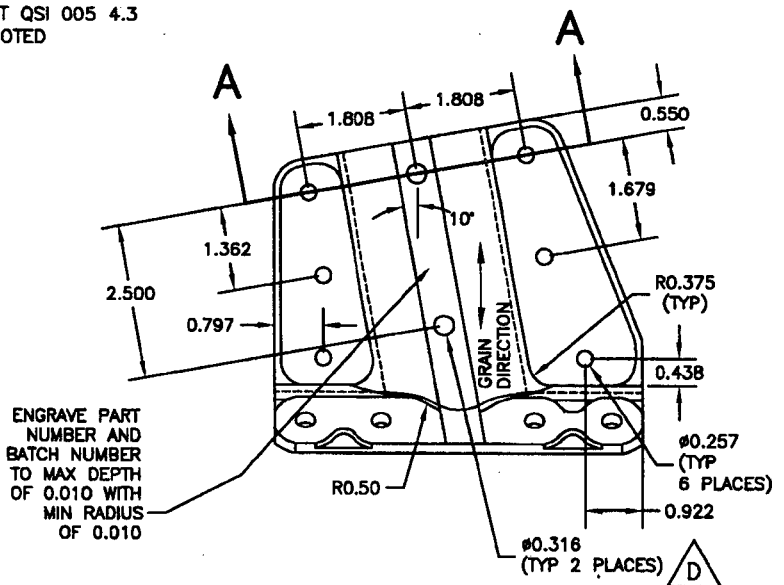
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 74356

M.L.J

11/09/28

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE****Copyright © 1997 by DART AEROSPACE USA, INC.**

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